

Date: Thursday, 12/15/2005 3:55:20 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GAS SPRING	
Job Number	: 25247		Part Number	: D2807	
Estimate Number	: 10336		Drawing Number	: D2807 REV C	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 12/15/2005 S.O. No. : N/A		Drawing Revision	: C	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 12/22/2005	
Previous Run	: 24622		Qty:	20	Um: Each
Written By	: SEE COMMENT BELOW				
Checked & Approved By	: SEE ABOVE USER & DATE.				
Comment	: Est: D 05.06.21 Removed painting; Changed supplier KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING Comment: PURCHASING Issue P/O: <u>00000304</u> <i>AP 05/12/06</i> Order as per Dwg D2807 Possible supplier: ArvinMeritor Motion Control Systems Material release note is required
2.0	D2807	Support Prop Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s) SUPPORT PROP
3.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC6	DIMENSIONAL CHECK Comment: DIMENSIONAL CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Install lugs and crimp using DT8791 crimp jig. 2-Remove lettering and logo with wash and wipe.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/05/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/05/05		2 D28073 hogs were installed from the batch that were no good (were drilled to deep) 2 shocks swapped.		give the 2 shocks to eng. steel replace. mount shocks				
				wrong	W/O			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SP

*parts used
in op A.*

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

1 Docks/10

Job Completion



u 06-05-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

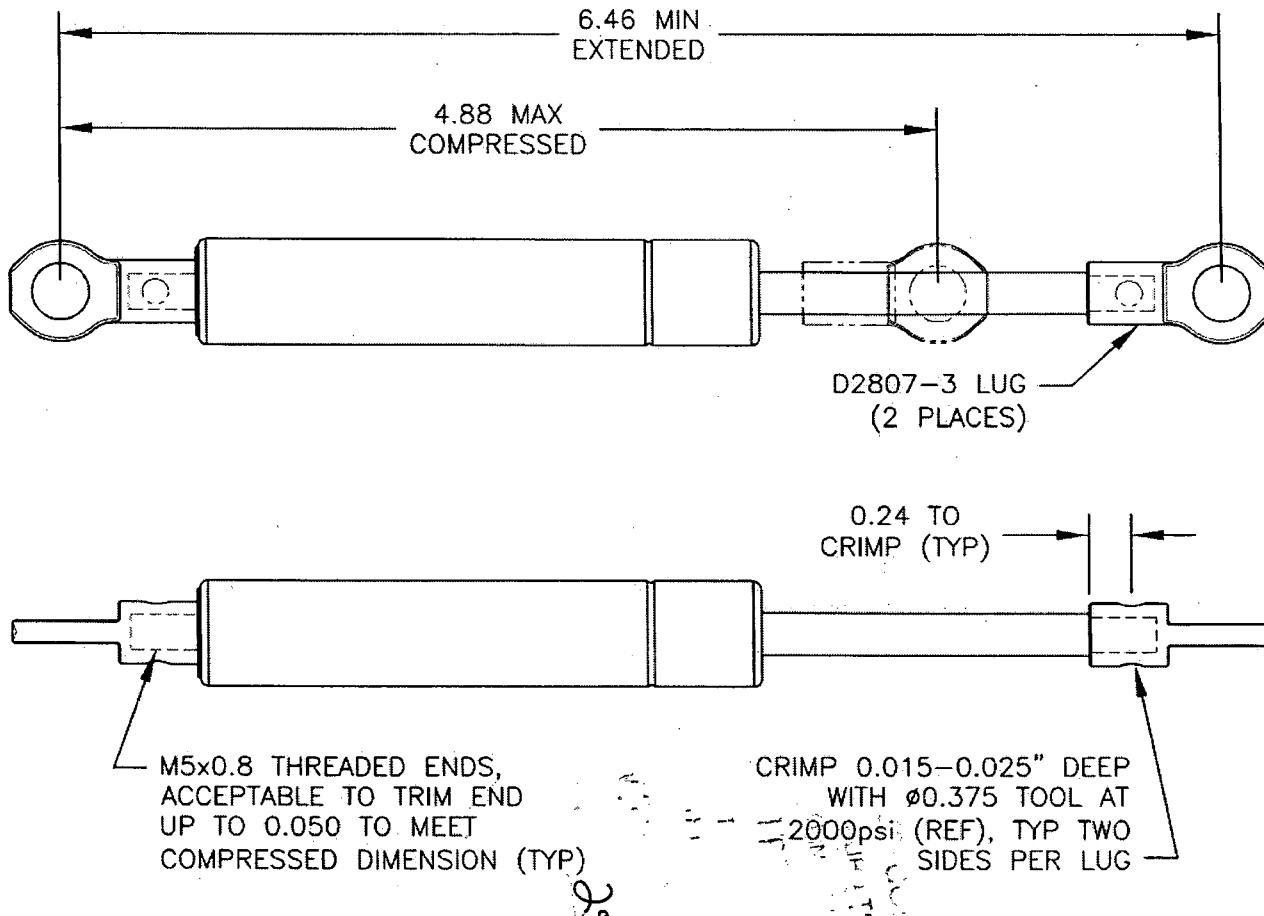
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
#05.06.16

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD		
CP	CP	HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. C	1 OF 2
DATE		TITLE		SCALE
05.05.25		GAS SPRING		1:1
A	00.11.03	NEW ISSUE		
B	05.03.16	ADD FINISH		
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG		



D2807 GAS SPRING

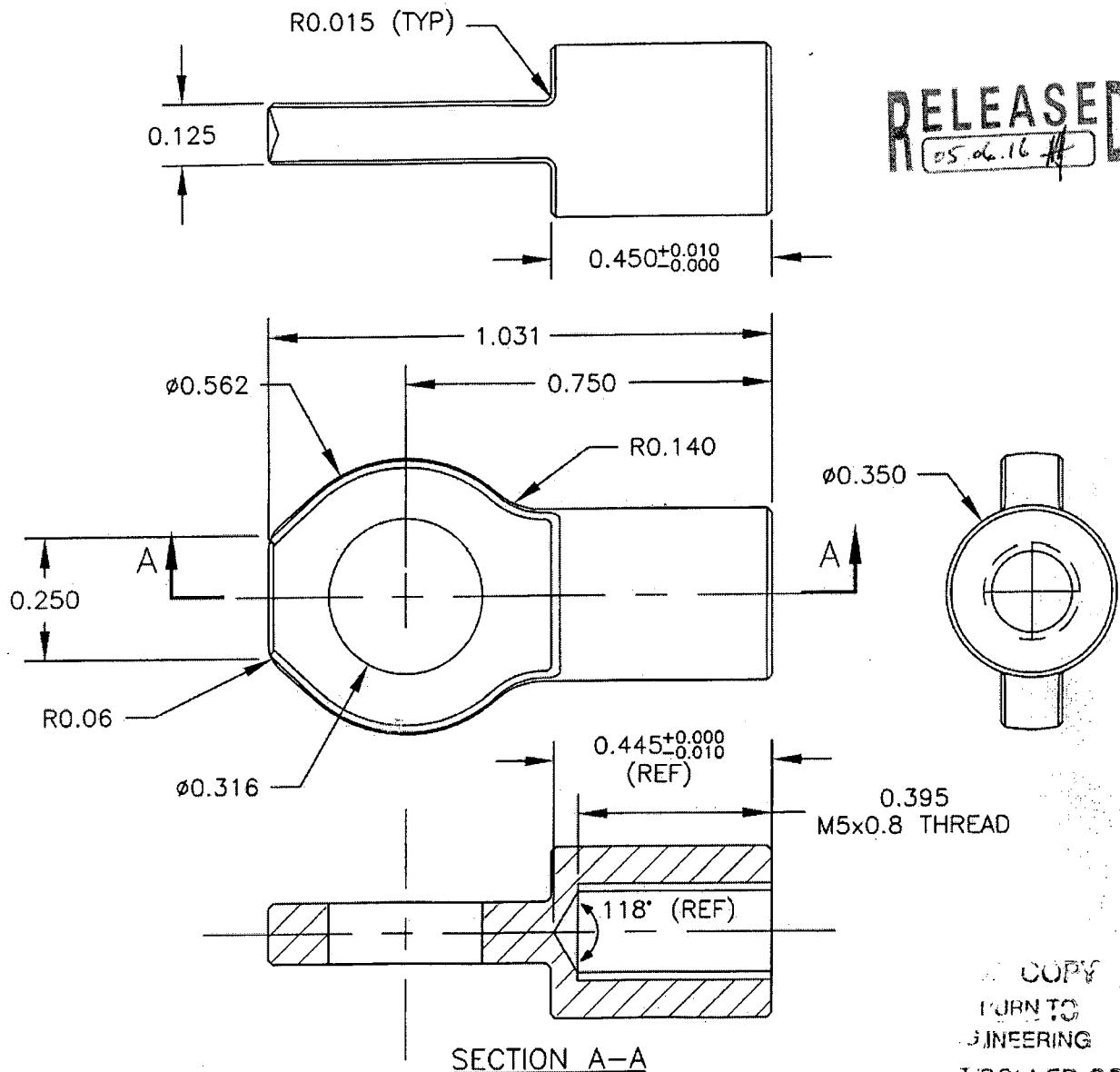
1) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>ff</i>	APPROVED <i>ff</i>	DRAWING NO. D2807
DATE 05.05.25	TITLE GAS SPRING	REV. C SHEET 2 OF 2 SCALE 3:1

**D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

COPY
 TURN TO
 ENGINEERING

TRACED COPY
 F T ENDMENT
 FICLT NOTICE

WORK ORDER
No. 25247

